

Work Order ID 53620

Page 1

November 10, 2009 2:56:34 PM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *V*

Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	SAY	09/11-12	x1	0.00	DS1 9473
D2512	Rev E	Large Fab	0.00					
100		Weld per dwg A/R S.S. rod Batch: M109213	0.00					
		Large Fab	0.00					
Large Fab		1-Cut 3/4" x 3/4" square tubing as per Dwg D2512	0.00					
Large Fab		2-Cut (4) D2236 From D3166-3	0.00					
		3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305	0.00					
		4-Weld as per Dwg D2512 using Welding Jig DT 9436	0.00					
		Deburr as required	0.00					
		INSTALL D2012-117 CLEVIS ONLY ON D130-701-041	0.00					
		5- Drill holes in D2512-1 per DS1 9473	0.00					
110		QC9- Inspect visual per QSI004- Fusion Welds	0.00					
		Memo	0.00					
QC			0.00					
Quality Control			0.00					

* Converted to Lot DS1 9473

Cpl 09/11/18

10/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53620

November 10, 2009 2:56:34 PM



Page 2

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

⇒ Solution

0.00

130



Powdercoat

Powder Coating

* PRESSURE WAS HI
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112148

0.00

⇒

M

09/11/19

(1) Ø

Memo

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 1:45pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:15pm

2ND COAT:

START TIME: 2:30pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:00pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53620

November 10, 2009 2:56:35 PM



Page 3

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

140



HandFinish

Hand Finishing

**Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

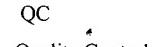
0.00

0.00

0.00

x1

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

0.00

∅.

160



Packaging

Packaging

Identify as per dwg & Stock Location: WYO 53618

0.00

0.00

0.00

BL 09-11-25.

CMD 09/11/26

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53620

Page 4

November 10, 2009 2:56:35 PM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

170



QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Memo

0.00

09/11/27 AF

PA 09-11-27
1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:56:30 PM

Page 1
4

Work Order ID: 53620



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 11/10/09

Required Date: 11/19/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	20.0000	2.0000			

Clevis

Warehouse
Location

Main Warehouse

ST	20
31101	2
52498	18

ONLY APPLICABLE ON D130-701-041

D2232-1RevC



Manufactured No

100 Each 18.0000 2.0000

Basket Hinge

Warehouse
Location

Main Warehouse

ST	2
48230	2

Main Warehouse

WA	16
51105	16

2x

11/09/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

November 10, 2009 2:56:31 PM

Work Order ID: 53620



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 11/10/09

Required Date: 11/19/09

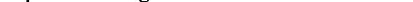
Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	33.0000	2.0000			

Spacer Bushing



Warehouse

Location

Main Warehouse

ST 33

51331 8

52832 25

2x 11/09/13

D2506RevF



Manufactured

No

100

Each

7.0000 1.0000



Label Plate

Warehouse

Location

Main Warehouse

ST 1

44275 1

Main Warehouse

WA 6

52834 6

1x 11/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

November 10, 2009 2:56:31 PM

Work Order ID: 53620



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 11/10/09

Required Date: 11/19/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	40.0000	2.0000			

Mounting Bracket



Warehouse

Location

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	9	

Main Warehouse

WA	28	
50872	1	
51745	27	

D3166-3RevA1



Manufactured

No

100

Each

5.8632 1.0000



Basket Hoop



Warehouse

Location

Main Warehouse

WA	5.8632	
50033	0.0527	
50618	0.1894	
52058	5.6211	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

November 10, 2009 2:56:32 PM

Work Order ID: 53620



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 11/10/09

Required Date: 11/19/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased		No		100	sf	191.7895	18.9474			

Expanded Metal Flat SS

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	191.7895065
110134	3.4
111630	1.85
111956	0.000017
112147	6.29428947
112311	0.9205
112707	43.6203
112949	135.7044

18.9474 84 09/11/12

M304TS0.750W.065

Purchased

No

100 f 481.2115 45.8741

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	473.6842
113082	473.6842

45,874

Main Warehouse

WA	7.5272947
112398	7.5272947

End Bar Scrap 0.7 sq ft B113082

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

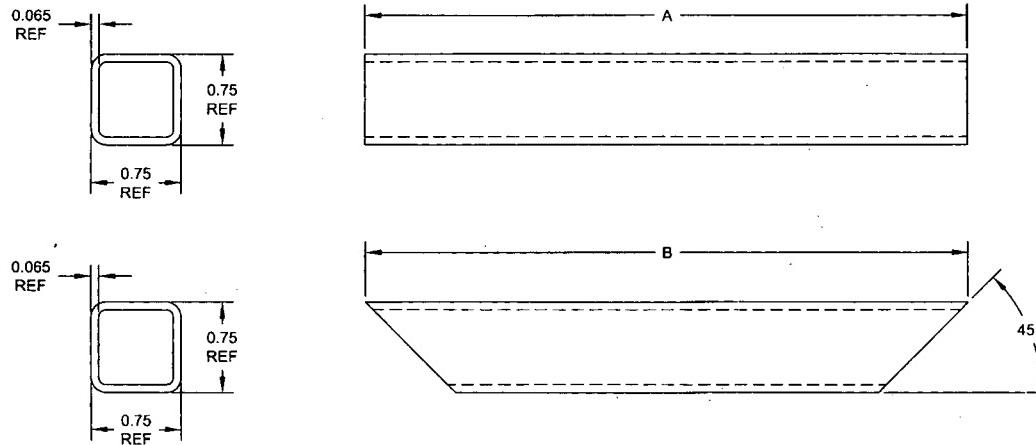
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

*WWD
53620*

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

RELEASED
(08.08.21)

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

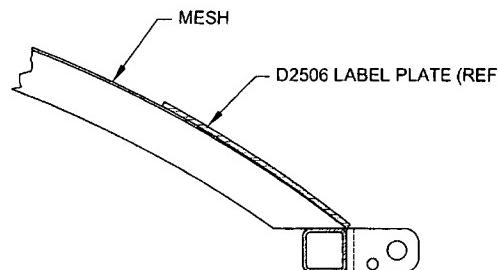
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. E	
MFG. APPR.		D2512 SHEET 1 OF 4	
APPROVED		TITLE SCALE	
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

1

WDS3620

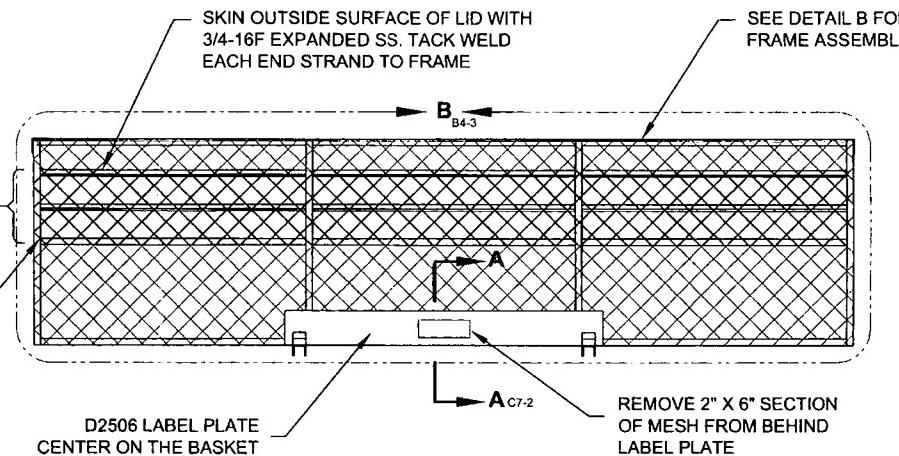
8 7 6 5 4 3 2 1



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG ENTIRE LENGTH PER NOTE 3 AFTER POWDER COAT.

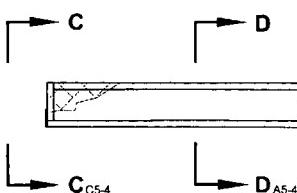
TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKIDDED



E

D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

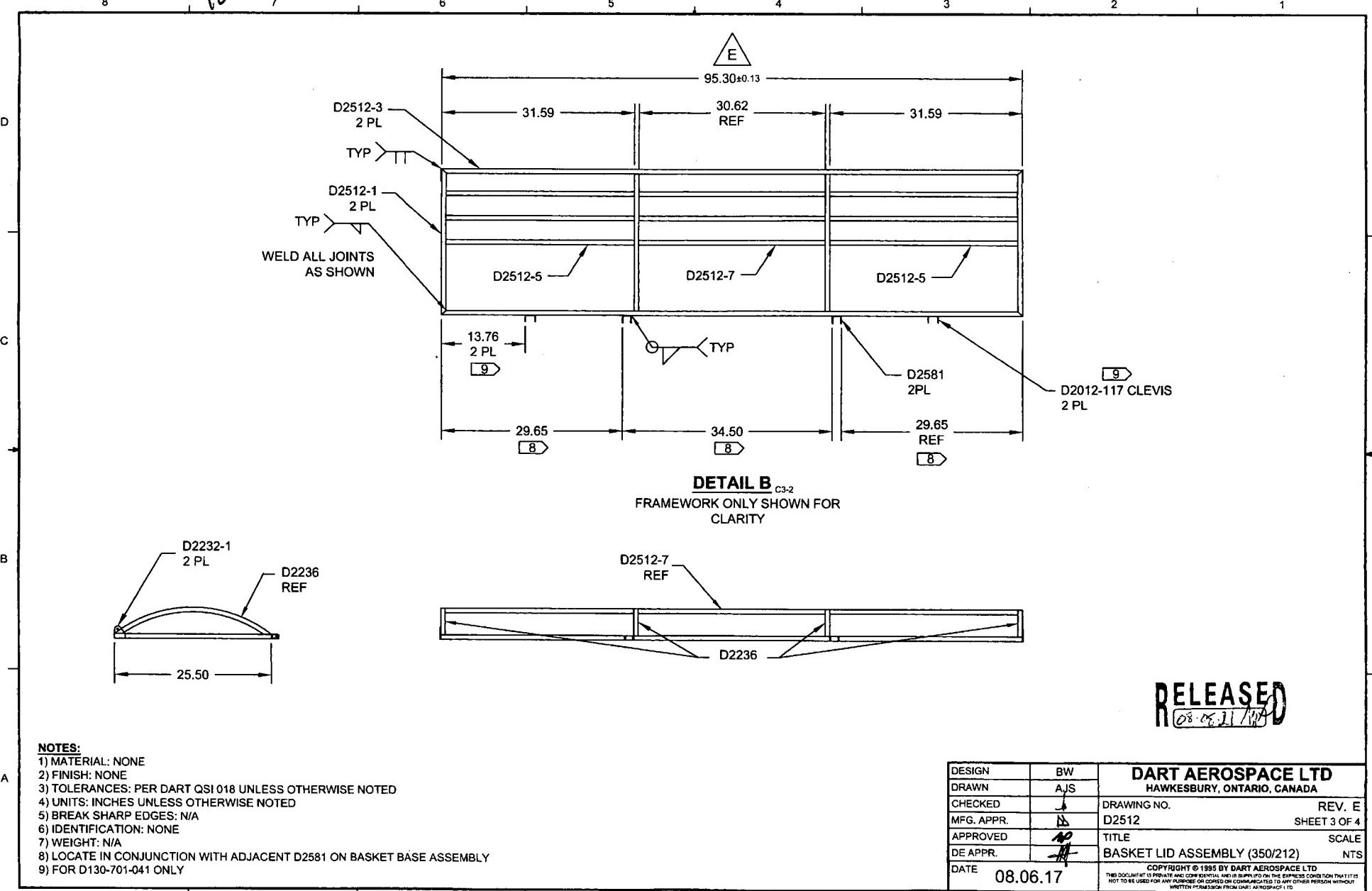


RELEASED
05.05.17

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. E
APPROVED		D2512
DE APPR.		SHEET 2 OF 4
DATE	08.06.17	TITLE
		SCALE
		BASKET LID ASSEMBLY (350/212) NTS
		COPYRIGHT © 1995 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

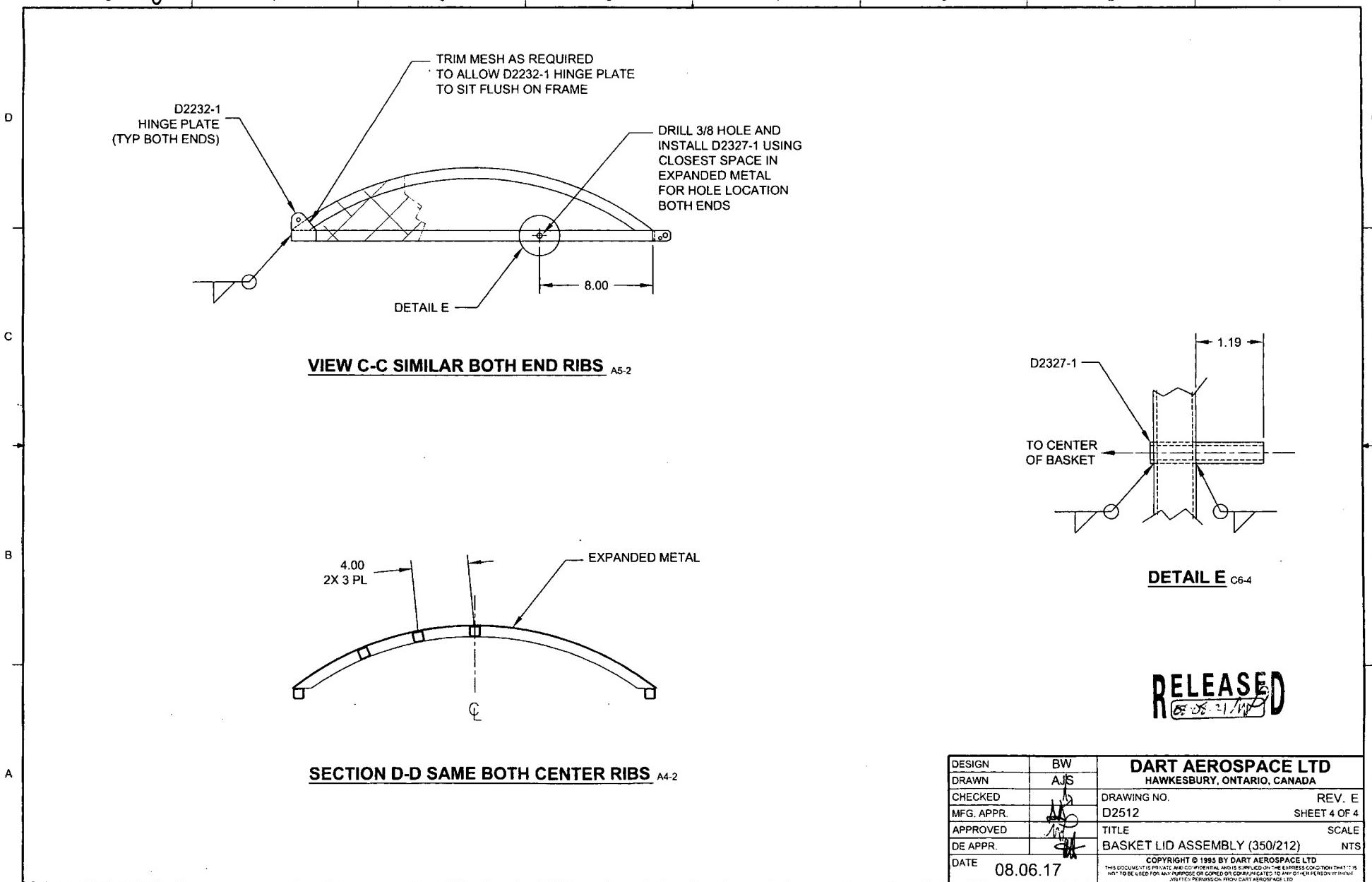
8 7 6 5 4 3 2 1

WJ0 53620



Wb 53620

8 7 6 5 4 3 2 1



DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	M	DRAWING NO. REV. E
MFG. APPR.	M	D2512 SHEET 4 OF 4
APPROVED	M	TITLE SCALE
DE APPR.	M	BASKET LID ASSEMBLY (350/212) NTS
DATE	08.06.17	Copyright © 1993 by Dart Aerospace Ltd THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

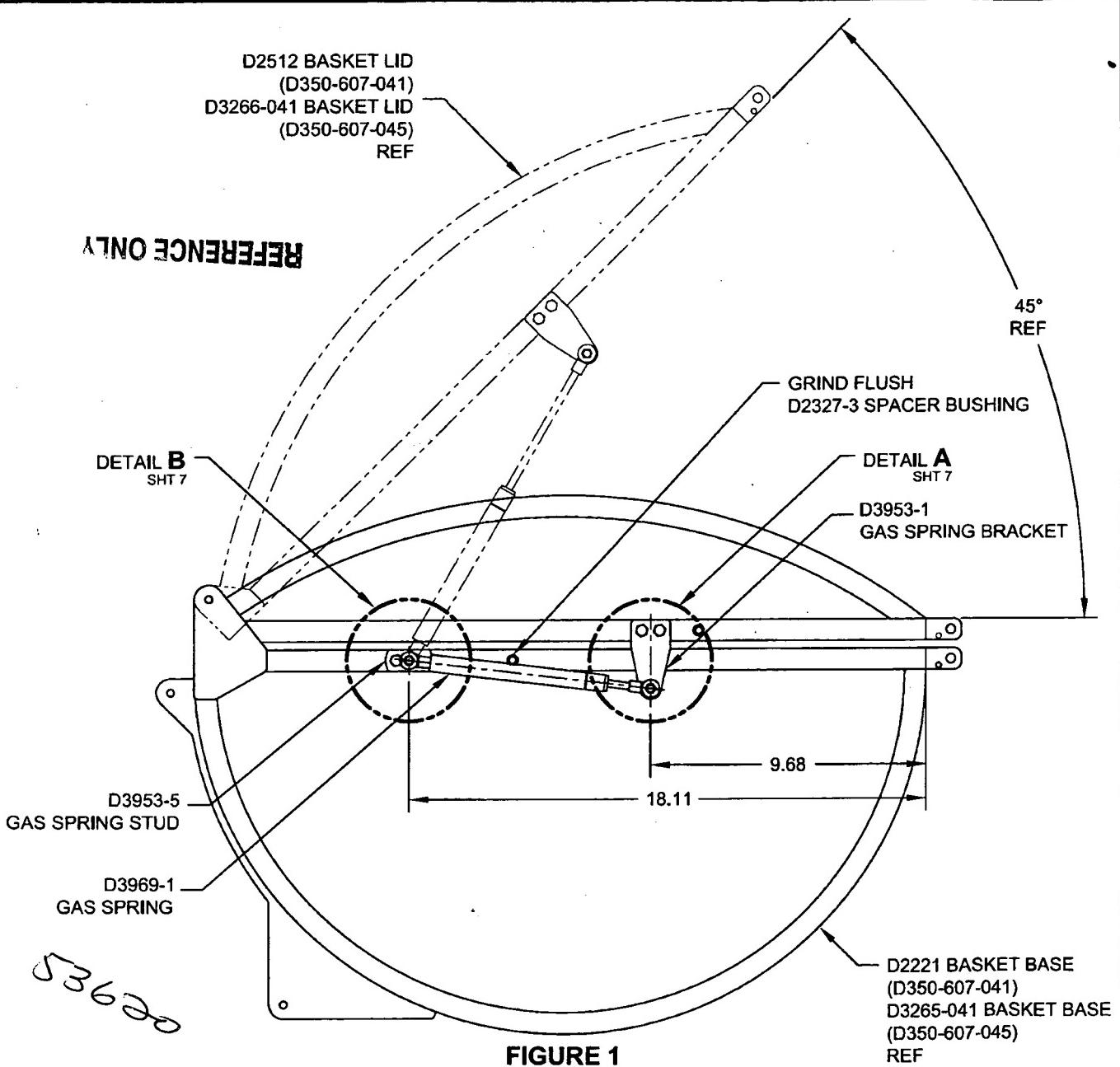


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
<i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.11.06
CERT. NO.:	SH94-14
ISSUE NO.:	4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9473	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE AUTOMATIC LID OPENER INSTL	
DE APPR.	<i>[Signature]</i>	SCALE	NTS
DATE	09.11.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	